



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2360

Job Sheet 202278



Part No: D2360

Job Qty: 15 pcs

Part Name: Litter Tie Down Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/23/19

Job Tracking No:

Due Date: 11/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D2341 REV G, D2360 REV D IPP rev H 07.06.12 ecn 825 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	15 pcs		11/18/19	0.00	0.50	Bandsaw - 1		
110	HAAS 4 Axis - B4B	15 pcs		11/18/19	0.26	22.39	HAAS - 1 - B4B		DTP 19-11-07
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	15 pcs		11/18/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



Container No: S229551



Part: D2360

Job No: 202278

Serial No/Batch: S229551

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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CANADA
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Date: 11/06/19

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				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	DIP 12-11-07
				QC 2 - 69	
				QC 8 - 12	
130 QC 8	15 pcs	11/18/19	0.00 0.00	QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	Hand 12/11/08
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140 Handfinish - 1-1 Chemical-B4B	15 pcs	11/18/19	0.00 1.17	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	NOV 12 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 -	

				B4B		
				Handfinish - 1 - 14 - B4B		
				Handfinish - 1 - 15 - B4B		
				Handfinish - 1 - 16 - B4B		
				Handfinish - 1 - 17 - B4B		
				Handfinish - 1 - 18 - B4B		
				Handfinish - 1 - 19 - B4B		
				Handfinish - 1 - 20 - B4B		
				Handfinish - 1 - 21 - B4B		
				Handfinish - 1 - 22 - B4B		
150	Powdercoat - 1 White GI(A)- B4B	15 pcs	11/18/19	0.00	0.75	Powdercoat - 1 - B4B
				Powdercoat - 2 - B4B		
				Powdercoat - 3 - B4B		
				Powdercoat - 4 - B4B		
160	QC 3	15 pcs	11/18/19	0.00	0.00	QC 3 - 10
				QC 3 - 13		
				QC 3 - 15		
				QC 3 - 17		
				QC 3 - 18		
				QC 3 - 2		
				QC 3 - 28		
				QC 3 - 3		
				QC 3 - 30		
				QC 3 - 34		
				QC 3 - 36		
				QC 3 - 41		
				QC 3 - 51		
				QC 3 - 58		
				QC 3 - 59		
				QC 3 - 68		
				QC 3 - 9		
				QC 3 - 40		
				QC 3 - 19		
				QC 3 - 43		
				QC 3 - 24		
				QC 3 - 61		
				QC 3 - 81		
170	Small Fab - 2 - B4B	15 pcs	11/18/19	0.00	4.72	Small Fab - 1 - B4B
				Small Fab - 2 - B4B		
				Small Fab - 3 - B4B		
				Small Fab - 4 - B4B		
				Small Fab - 5 - B4B		
				Small Fab - 6 - B4B		
				Small Fab - 7 - B4B		
				Small Fab - 8 - B4B		
180	QC 5	15 pcs	11/18/19	0.00	0.00	QC 5 - 10
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		

						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
190 Packaging 3-1 - Stock - B4B	15 pcs	11/18/19	0.00	0.00		Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B ✓	ST225
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	

Oscar

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					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
200 QC 21 - SA	10	15 pcs	11/18/19	0.00 0.00	QC 21 - SA - 21 ✓	ST225
					QC 21 - SA - 70	DAS
					QC 21 - SA - 53	21

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Part Op 100 - (Bandsaw) Cut blanks: 12.65" Long
 Descriptions: 110 - (HAAS CNC vertical machine #1) 1-Machine as per Folio D2341 and Dwg D2341 2-Deburr
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
 160 - (QC3- Inspect Part Finish)
 170 - (Small Fab) Assemble as per dwg D2366
 180 - (QC5- Inspect part completeness to step on W/O)
 190 - (Identify as per dwg & Stock Location: _____)
 200 - (QC21- Final Inspection - Work Order Release)

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6201	T Extrusion	15.8100 ft (1.054 ea)	100-Bandsaw - 1	5229069
AN526C1032R18	Screw	15 Ea (1 ea)	170-Small Fab - 2 - B4B	5230630
D2002-015	Knob	30 pcs (2 ea)	170-Small Fab - 2 - B4B	5194795
D2345	Lock Channel	15 pcs (1 ea)	170-Small Fab - 2 - B4B	5194795
D2366	Lock Handle	30 pcs (2 ea)	170-Small Fab - 2 - B4B	5210448
D2367	Handle Knob	15 pcs (1 ea)	170-Small Fab - 2 - B4B	5198547
D2372	Quick Release	30 pcs (2 ea)	170-Small Fab - 2 - B4B	5230630
D2373	Spring	15 pcs (1 ea)	170-Small Fab - 2 - B4B	516162
D2444	Pip Pin Assembly	15 pcs (1 ea)	170-Small Fab - 2 - B4B	5231314
MS20470AD3-4	Rivet, Universal Head	15 Ea (1 ea)	170-Small Fab - 2 - B4B	5231314
MS21042L3	Nut	45 Ea (3 ea)	170-Small Fab - 2 - B4B	5231314
MS27039-1-13	Screw	15 Ea (1 ea)	170-Small Fab - 2 - B4B	5231314
MS27039-1-15	Screw	30 Ea (2 ea)	170-Small Fab - 2 - B4B	5231314
NAS1149D0332J	Washer	120 Ea (8 ea)	170-Small Fab - 2 - B4B	5231314
NAS1149D0363J	Washer	30 Ea (2 ea)	170-Small Fab - 2 - B4B	5231314
NAS679A3W	Nut	15 Ea (1 ea)	170-Small Fab - 2 - B4B	5231314

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	D6201	16	17	0
170-Small Fab - 2 - B4B	AN526C1032R18	15	38	0
	D2002-015	30	29	0
	D2345	15	5	0
	D2366	30	13	0
	D2367	15	36	0
	D2372	30	16	0
	D2373	15	14	0
	D2444	15	3	0
	MS20470AD3-4	15	5,131	0
	MS21042L3	45	2,767	0
	MS27039-1-13	15	286	0
	MS27039-1-15	30	183	0
	NAS1149D0332J	120	1,498	0
	NAS1149D0363J	30	887	0
	NAS679A3W	15	6	0

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Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Part No. _____	Rework ☐ Scrap ☐ Use-as-is ☐				
Date: _____	Sequence #: _____	QTY Affected: _____			
Description Work Order Deviation		Disposition			
		Completed By			
		Lead hand / Supervisor			
		QC / QA Coordinator			
Root Cause		FAULT CATEGORY			
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____	Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐